

# Work Order ID 66881

Wednesday, March 02, 2011 7:55:53 AM

Page 1

Item ID: D3610-041

Revision ID:

Item Name: Bracket

Start Date: 3/2/2011

Start Qty: 10.00

Required Date: 3/7/2011

Req'd Qty: 10.00

Reference:

Accept

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3610

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 6.600 " long

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA692 Rev: AA & Dwg D3610 Rev: A ☐ 2-Deburr per dwg D3610

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 66881**

Wednesday, March 02, 2011 7:55:53 AM



Page 2

Item ID: D3610-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 3/2/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC8- Inspect parts - second check

0.00

JL 11/03/14



QC

Memo

0.00



Quality Control

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-C'SINK AS PER DWG D3610

EP 11/03/15 (7)

150

QC5- Inspect part completeness to step on W/O

0.00

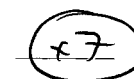


QC

Memo

0.00

Sul 03/15



Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 66881

Wednesday, March 02, 2011 7:55:53 AM



Page 3

Item ID:	D3610-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Bracket				Stop	
Start Date:	3/2/2011	Start Qty:	10.00			
Required Date:	3/7/2011	Req'd Qty:	10.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>M 115128</i> Memo START TIME: <i>3:15</i> <i>3:20</i> FINISH TIME: <i>3:45</i> <input type="checkbox"/> OVEN TEMPERATURE:	0.00 0.00				<i>7</i>	<i>BL 11-3-15</i>		
170  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00				<i>7</i>	<i>0</i>	<i>11/03/16</i>	
180  Small Fab Small Fab	Small Fab Memo Rivet Nut Plate as per Dwg D3610	0.00 0.00						<i>7</i>	

*ES 11/03/16 (7)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			






**NOTE:** Date & initial all entries



**Work Order ID 66881**





Wednesday, March 02, 2011 7:55:53 AM



Page 4

Item ID: D3610-041 Accept  Setup Start   
Revision ID: Stop   
Item Name: Bracket  
Start Date: 3/2/2011 Start Qty: 10.00  Cust Item ID:  
Required Date: 3/7/2011 Req'd Qty: 10.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00					11	03	16 (7)
200  Packaging Packaging	Identify as per dwg & Stock Location <u>248A</u>  Memo	0.00  0.00					11/3/16	70	P
210  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00					11/3/17		J

CL 11/03/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, March 02, 2011 7:56:01 AM

Page 1

Work Order ID: 66881

Parent Item: D3610-041

Parent Item Name: Bracket

Start Date: 3/2/2011

Required Date: 3/7/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A new issue 07.03.28 EC  
IPP rev B released, changed mat'l EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M4140N-  
B1.500X1.5000

Purchased

No

100

f

14.7600

0.5775

5.775



4140 Steel Bar 1.50 x 1.50



Location

Loc Qty

Loc Code

MAT

14.76

112397

12

115869

2.76

MS20426AD3-4

Purchased

No

110

Each

5,343.000

2

20



RIVET



Location

Loc Qty

Loc Code

ST316

5343

104374

1343

110398

4000

MS21075L3

Purchased

No

180

Each

168.0000

1

10



Nutplate



Location

Loc Qty

Loc Code

ST302

150

116706

150

ST303

17

113734

1

116513

16

ST350

1

115908

1

1.155 on 11/03/10  
2.76

EP 11/03/10

14

EP 11/03/10

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

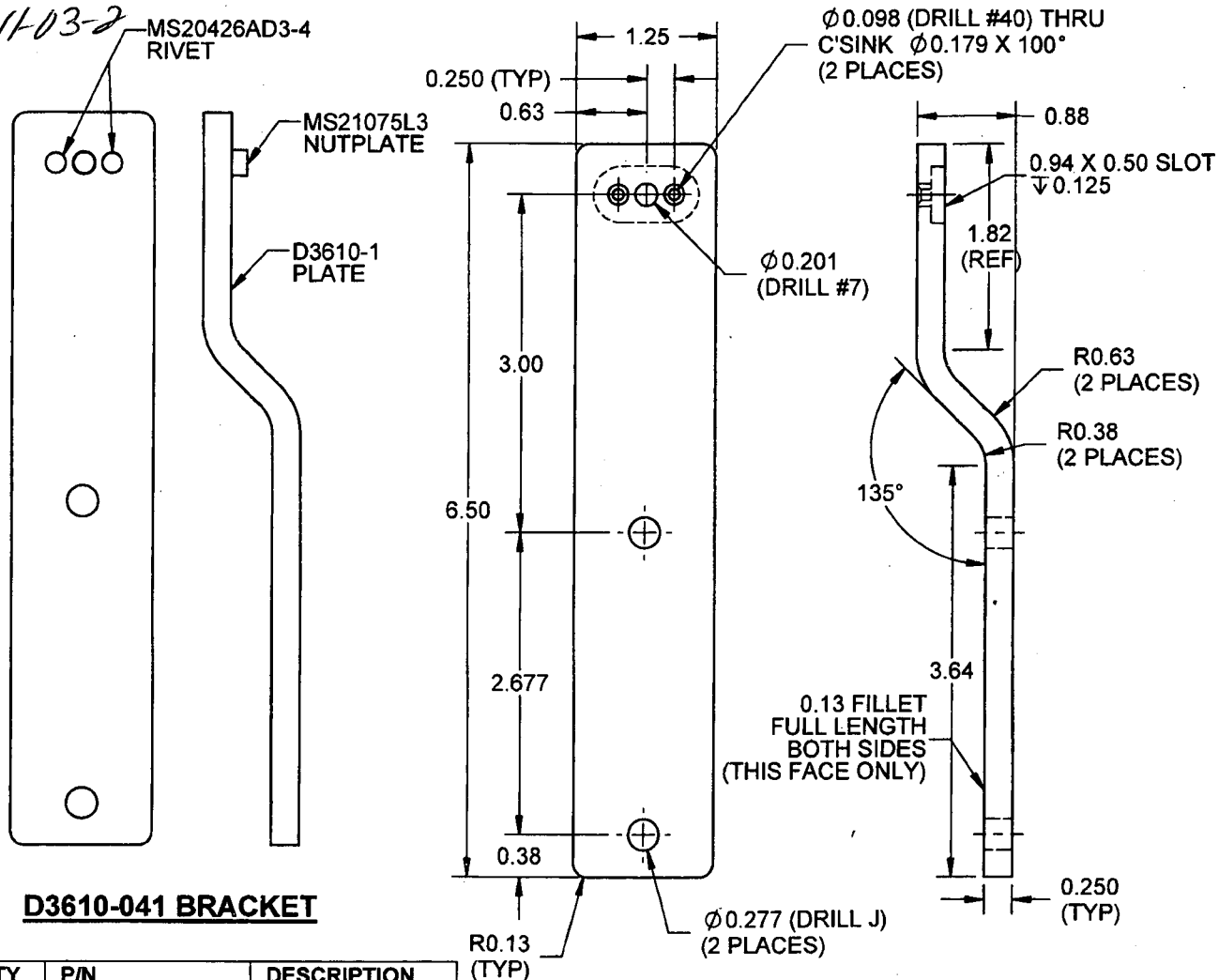
SH  
RE  
ENC

**DART**

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3610</b>	REV. A SHEET 1 OF 1
DATE <b>07.04.20</b>	TITLE <b>BRACKET</b> SCALE 2:3		
REV A	DATE 07.04.20	DESCRIPTION NEW ISSUE	

WITHOUT NOTICE  
WORK ORDER  
NO. *66881*



**D3610-041 BRACKET**

**D3610-1 PLATE**

QTY	P/N	DESCRIPTION
X	BRACKET	D3610-041
1	D3610-1	PLATE
1	MS21075L3	NUTPLATE
2	MS20426AD3-4	RIVET

**RELEASED**

07.04.25 *[Signature]*

**D3610-041 NOTES:**

1) IDENTIFY WITH DART P/N "D3610-041" USING FINE POINT PERMANENT INK MARKER

**D3610-1 NOTES:**

- 1) MATERIAL: 4130N STEEL BAR PER MIL-S-6758 OR AMS 6348 OR 6370 OR 6528 (REF DART SPEC M4130N-B) OR 4140N STEEL BAR PER MIL-S-5626 OR AMS 6382 OR 6349 OR 6529 (REF DART SPEC M4140N-B)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries


<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 66881
<b>Description:</b> BRACKET	<b>Part Number:</b> D3610-041
<b>Inspection Dwg:</b> D3610 , <b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25	+/- .030	1.251	✓		Vern	GA -01
0.250	+/- .010	0.250	✓		"	"
0.63	+/- .030	0.624	✓		"	"
3.00	+/- .030	3.000	✓		"	"
6.50	+/- .030	6.503	✓		Vern	CNC -02
2.677	+/- .010	2.677	✓		Vern	GA -01
0.38	+/- .030	0.374	✓		"	"
R0.13	+/- .030	R0.125	✓		R-6	ref.
Ø0.277	+ .006 / - .001	Ø0.278	✓		Vern	GA -01
Ø0.201	+ .005 / - .001	Ø0.202	✓		"	"
Ø0.098	+ .004 / - .001	Ø0.100	✓		"	"
0.88	+/- .030	0.872	✓		H-6	31006
0.94 x 0.50	+/- .030	0.938 x 0.500	✓		Vern	GA -01
0.125	+/- .010	0.124	✓		D-6	GA -08
R0.63	+/- .030	R0.063	✓		R-6	ref.
R0.38	+/- .030	R0.375	✓		"	"
0.250	+/- .010	0.251	✓		Vern	GA -01
0.13	+/- .030	0.125	✓		"	"
3.64	+/- .030	3.640	✓		"	"
135°	+/- 1/2°	135°	✓		Angle meter	CNC -08

<b>Measured by:</b> M.A.
<b>Date:</b> 11/03/10

<b>Audited by:</b> 
<b>Date:</b> 11/03/14

<b>Prototype Approval:</b>
<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	